January 11, 2010 11:36:10 AM



Page 1

Item ID:

D3790-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

INDEXING BLOCK

**Start Date:** 

1/11/2010

Start Qty: 6.00

Required Date: 1/18/2010

QC:

Reg'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: MF

Date: 10 - 01-11 Tooling:

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Date:

Accept

Reject Qty

Reject Insp. Number

**Work Center ID** 

Sequence ID/

Description

Operation

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Plan Code

Qty

Stamp

**Draw Nbr** 

**Revision Nbr** 

D3790

Rev B

100

Bandsaw

Memo

0.00

0.00

10.01.14

Jeaspa Bandsaw

CUT BLANK 5.90" LONG

110

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

0.00

MILL AS PER DWG AND FOLIO FA745 FOLIO REV:

DWG REV:

**DEBURR** 

Dart	<b>Aeros</b>	pace	Ltd

W/O: WORK ORDER CHANGES								
DATE	STEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvai QC Inspector
				·				

Part No: P	AR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANO	CE (NCR)			
D.475	0.770	Description of NC Corrective Action Section B				Verification	Approval	Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
الم. ور	20	2.100 DIMENSION OUT OF TOLERANCE, CORRector error.	Possen	Ofyx Scrap + doit replace	pl. it	2	B avers	2
0,					10.10	Colorlas		(0/31/19

Page 2

Item ID:

D3790-1

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

INDEXING BLOCK

**Start Date:** 

Required Date: 1/18/2010

1/11/2010

QC:

Start Qty: 6.00 Req'd Qty: 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID** 

120

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 

0.00

0.00

Draw Number

10.01.14

Plan Draw Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

**Quality Control** 

QC8- Inspect parts - second check

Memo

0.00

It 10/01/19

130

OC

**Quality Control** 

Identify as per dwg & Stock Location:

Memo

140

Packaging Packaging

Memo

0.00

0.00

10-1-19 5x Sf

W/O:		-	V	VORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
,								-	
						,			
<del></del> -									
Part No: PAR #:		PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DO	QA:	_ Date: _	
		esolution:	_ Disposit	ion:	QA: N/C	Closed: _		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval
- DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ction C	Chief Eng	QC Inspector
								:	

#### Work Order ID 55190

January 11, 2010 11:36:10 AM



Page 3

Item ID:

D3790-1

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name:

Required Date: 1/18/2010

INDEXING BLOCK

1/11/2010

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Operation Description

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Plan Code Qty

Reject Accept Qty

Reject Number

Insp. Stamp

**Work Center ID** 

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

**Quality Control** 

150

QC

W/O:	Ī	1.01	\8/	ORK ORDER CHANG	· EC				
DATE	STEP	PRO	PROCEDURE CHANGE  By Date Qty Chief Eng Prod Mgr			By Date Qty C			Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sign Date	&   Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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#### **Picklist Print**

January 11, 2010 11:36:10 AM

Work Order ID: 55190

Parent Item: D3790-1

Parent Item Name: INDEXING BLOCK

IPP Rev:A New Issue 08-05-16 JLM Verified By:DD Component Item ID/

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location

Route Unit of Seq ID

f

Qty on Measure Hand

Remaining Qty To Pick

Start Qty: 6.00

**Start Date:** 1/11/2010

Date

Status

MDELRINB2.000X3.00

Comments:

Item Name

Purchased

No

8.3900

3.1200

Qty

Issued

Issued

Required Date: 1/18/2010

Required Qty: 6.00

Page 1

Delrin Bar 2" x 3"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

108068

112665

8.39

. 0.39 8

p.01.14

	1100	WC	RK ORDER CHAI	NGES					
STEP	PRO	OCEDURE CHA	NGE	By Date Qty Approval Chief Eng / Prod Mgr				Approval QC Inspector	
		10 to							
		Fault Cate	gory:	NCF	l: Yes	No DQ	<b>\</b> :	_ Date: _	
Re	solution:	Dispositio	n:	QA:	QA: N/C Closed: Date:				
	,	WORK ORDI	ER NON-CONFOR	MANCE	(NCR	)			
STED	Description of NC						ation	Approval	Approval
SILF	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date			Chief Eng	QC Inspector
					Martine and the				
		:PAR #: Resolution:	STEP PROCEDURE CHARGE  PAR #: Fault Cates  Resolution: Disposition  WORK ORDI  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFOR  STEP Description of NC Section A  Section A  Initial Action Description	PAR #: Pault Category: NCR  Resolution: Disposition: QA:  WORK ORDER NON-CONFORMANCE  STEP Description of NC Section A Initial Action Description	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C Clo  WORK ORDER NON-CONFORMANCE (NCR  STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQA  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

DART AEROSPACE LTD	Work Order:	5379C
Description: Indexing Block	Part Number:	D3790-1
Inspection Dwg: D3790 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype	X First Article
---------------------------	-----------------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	. 213	;			
0.450 deep	+/-0.010	,450				
0.05 x 45°	+/-0.010 x 0.5°	,05 x450				
1.265	+/-0.010	1.265				
1.699	+/-0.010	1.697				
2.166	+/-0.010	2.166				
2.662	+/-0.010	2,662				·
1.300	+/-0.010	1.360				
1.629	+/-0.010	1629				
1.910	+/-0.010	1.910				
2.138	+/-0.010	2.138				
R0.25	+/-0.030	2.25				
R3.62	+/-0.030	R3.62				
R4.249	+/-0.010	R4,249				
R5.50	+/-0.030	R5.50				
19°	0.5°	190				
51°	0.5°	510				
Ø0.525	+0.008/-0.001	1525				
Ø0.281	+0.006/-0.001	, 281				
Ø0.625	+0.008/-0.001	-625				
4.97	+/-0.030	4.97				
3.100	+/-0.010	3.100				
1.038	+/-0.010	1.038				
0.500	+/-0.010	A. 10,500				
2.100	+/-0.010	2.100				
12°	0.5°	,20				
1.42	+/-0.030	1.42				
1.13	+/-0.030	1.13				
0.38	+/-0.030	.38				
0.50	+/-0.030	. 50				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 60-0/. 14	Date: 10/01/19	Date:	N/A

Rev	Date	Change	Revised by	٧.	Approved
Α	09.05.19	New Issue	KJ C	A	N.

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
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					ng.			-		

8 D С UPDATED NOTE 1 (ZN A8-1); Ø0.209 WAS Ø0.250 AND 4 PL WAS 5 PL (ZN D5-2); 19 "WAS 25" (ZN C7-2). REASON: REDESIGNED TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN D3705-041 AND D3676-1 AT INSTALLATION В мв 08.06.26 Α NEW ISSUE 08.05.13 REV. DESCRIPTION BY DATE **D3790-1 INDEXING BLOCK** DESIGN NOTES:

(REF DART SPEC M-DELRIN-B)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: SCRIBE WITH DART P/N "D3790-1" USING VIBRATING STYLUS

7) WEIGHT: 0.39 lbs DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3790 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE INDEXING BLOCK DE APPR. NTS

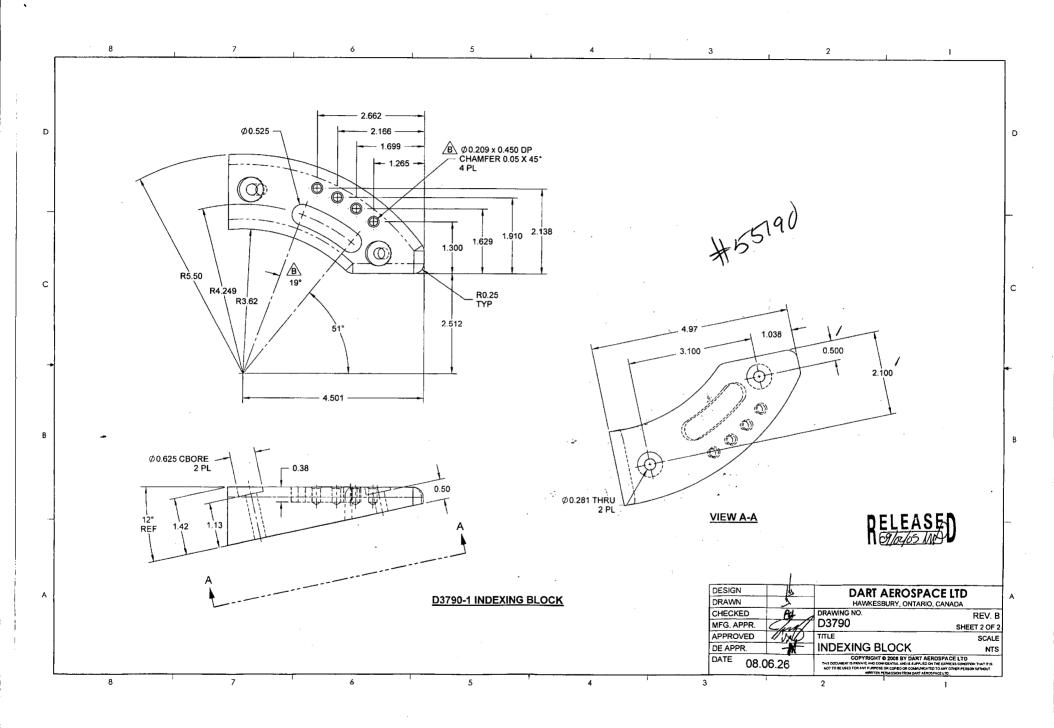
COPYRIGHT 2 2008 BY DART AEROSPACE LTD
100 DODAMENT OF PROVIDE AND COMPORTAL AND SUPPLIED ON THE COPIESS SONOTO THAT IT IS
NOT TO RE USED FOR ALL WEIGHT OF COMPOSITION OF THE OPERAN WITHOUT
WITHTEN PERMISSION FROM DART AEROSPACE LTD.

DATE

3

08.06.26

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		*											
					···					·			
							•						
		PAR #:											
Resolution:			Disposition: QA			A: N/C Closed: Date:							
NCR:			WORK ORDE	R NON-CONFO	RMANCE	(NCF	?)						
		Description of NC Section A	Corrective Action Section B				Verific	ation	Approval	Approval			
DATE	STEP		Initial Chief Eng	Action Descrip Chief Eng	tion	Sign 8 Date	Section		Chief Eng	QC Inspector			
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W/O:		WORK ORDER CHANGES										
DATE STEP		PRO	OCEDURE CHAI	NGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date:				
	R	solution: Disposition:			QA: N/C Closed: Date:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)						
DATE	STEP	Description of NC			on B	Verific	cation	Approval	Approval			
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector			
						-						